

Date: Wednesday, 30/07/2008 5:33:21 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: AFT FACING SEAT ASS'Y RH		
Job Number	: 40827					
Estimate Number	: 13314					
P.O. Number	:			Part Number	: D412769044	
This Issue	: 30/07/2008	S.O. No. :		Drawing Number	: D412-769-2 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: SMALL /MED FAB		
Previous Run	: 40826			Drawing Revision	: B	
Written By	:			Material	:	
Checked & Approved By	: JUL 08.8.01			Due Date	: 15/08/2008	
Comment	: Est rev A 08-05-12 new issue DD verified by:ec			Qty:	1 Um: Each	
Est Rev:B 08-07-17 revB as per dwg DD verified by:ec						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
	Comment: PACKAGING RESOURCE #1		
	Pick Packing Kit		
2.0	D3782045	Back Leg Assembly	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
	Back Leg Assembly		
	batch: 40873-2		FF 08/09/17
3.0	D3782041	Front Inboard Leg Assembly	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
	Front Inboard Leg Assembly		No Qty
	batch: 40870-2		FF 08/09/17
4.0	D3782044	Front Outboard Leg Assembly, RH	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
	Front Outboard Leg Assembly, RH		No Qty
	batch: 40872-2		FF 08/09/17
5.0	D3783041	Lateral Brace Assembly	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
	Lateral Brace Assembly		AS 08/09/18
	batch: 40874		(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASSY RH

Job Number: 40827

Part Number: D412769044

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D3783043 Longitudinal Brace Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Longitudinal Brace Assembly

batch: 40875

AS 08/09/08 (R)

7.0 D3783045 Angle Brace Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Angle Brace Assembly

batch: 40876

No Axis

FF 08/09/17

8.0 D3784041 Seat Support Assembly, Center



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, Center

batch: 40877

AS 08/09/08 (R)

9.0 D3784043 Seat Support Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, LH

batch: 40878

AS 08/09/08 (R)

10.0 D3784044 Seat Support Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, RH

batch: 40879

AS 08/09/08 (R)

11.0 D37662 Front Rail, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Front Rail

batch: 40864

AC 08/09/08 (R)

12.0 D37663 Rear Rail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rear Rail

batch: B40865

AS 08/09/08 (R)

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40827

Part Number: D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :
13.0	D37671	Upper Rail
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Upper Rail batch: B40366 AS 08/09/08
14.0	D37921	Seat Belt Eye Bolt
		Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s) Seat Belt Eye Bolt batch: B41521x1 B41878 x2 AS 08/09/08
15.0	AN415A	Bolt
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Bolt batch: M168077 AS 08/09/08
16.0	AN45 13A	EYE BOLT
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) EYE BOLT batch: M167938 AS 08/09/08
17.0	AN510A	Bolt
		Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s) Bolt batch: M168471 AS 08/09/08
18.0	AN513A	Bolt
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Bolt batch: M168167 AS 08/09/08
19.0	AN960JD10	Washer
		Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s) Washer batch: M169059 (or NAS1149D0363J) AS 08/09/08

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40827

Part Number: D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :
20.0	AN960JD416	Washer
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Washer batch: _____ (or NAS1149D0463J) batch: M168161	AS 08/09/08 (X)
21.0	AN960JD516	Washer
	Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s) Washer batch: _____ (or NAS1149D0568J) batch: M16867J	AS 08/09/08 (X)
22.0	AN52510R24	Screw
	Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s) Screw batch: _____ M168270	AS 08/09/08 (X)
23.0	MS21042L3	Nut
	Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s) Nut batch: _____ M168761	AS 08/09/08 (X)
24.0	MS21042L4	Nut
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Nut batch: _____ M167499	AS 08/09/08 (X)
25.0	MS21042L5	Nut
	Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s) Nut batch: _____ M168161	AS 08/09/08 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40827

Part Number: D412769044

Job Number:



Seq. #: Machine Or Operation:

Description :

26.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D412-769-2

FF 08/09/17

①

27.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

28.0 POWDER COATING POWDER COATING



M1064472

Comment: POWDER COATING

1- mask D3782-041 and D3782-043 front legs and D3787-1 foot as per dwg D412-769-041

2- Powder coat remainig of assembly grey as per dwg D412-769-2

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

11:00 AM

OVEN TEMPERATURE:

320°F

FINISH TIME:

11:30 AM

4 08-09-17

STR40

29.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 08/09/17

1X

30.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0 D37751 Guard



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Guard

batch:

40869

8 08/09/08 X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: AFT FACING SEAT ASS'Y RH
Job Number: 40827		Part Number: D412769044
Job Number:		
Seq. #:	Machine Or Operation:	Description :
32.0	D37741	Seat Bottom, LH/RH 
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Seat Bottom, LH batch: B41084	AS 08/09/08 (X)
33.0	D37743	Seat Back, LH/RH 
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Seat Bottom, LH batch: 41085	AS 08/09/08 (X)
34.0	AN525 10R22	Screw 
		
	Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s) Screw batch: M107936	AS 08/09/08 (X)
35.0	AN960JD10L	Washer 
		
	Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s) Washer batch: M105793 (or NAS1149D0332J) batch:	AS 08/09/08 (X)
36.0	MS21042L3	Nut 
		
	Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s) Nut batch: M108701	AS 08/09/08 (X)
37.0	AN35A	Bolt 
		
	Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s) Bolt batch: M100188	AS 08/09/08 (X)
38.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
		
	Comment: SMALL & MEDIUM FAB RESOURCE 1 1- install remaining parts as per dwg D412-769-2	FF 08-09-17 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40827

Part Number: D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :
39.0	QC5	INSPECT WORK TO CURRENT STEP
		<i>S68/09/17</i>
40.0	PACKAGING 1	PACKAGING RESOURCE #1
		<i>AS 08/09/18</i>
41.0	QC21	FINAL INSPECTION/W/O RELEASE
		<i>08/09/18</i>
		<i>MF 08-09-18</i>
<p>Comment: INSPECT WORK TO CURRENT STEP</p> <p>Identify and Stock</p> <p>Location: <i>PPQ 40827</i></p> <p>Comment: PACKAGING RESOURCE #1</p>		

Job Completion



W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

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C

B

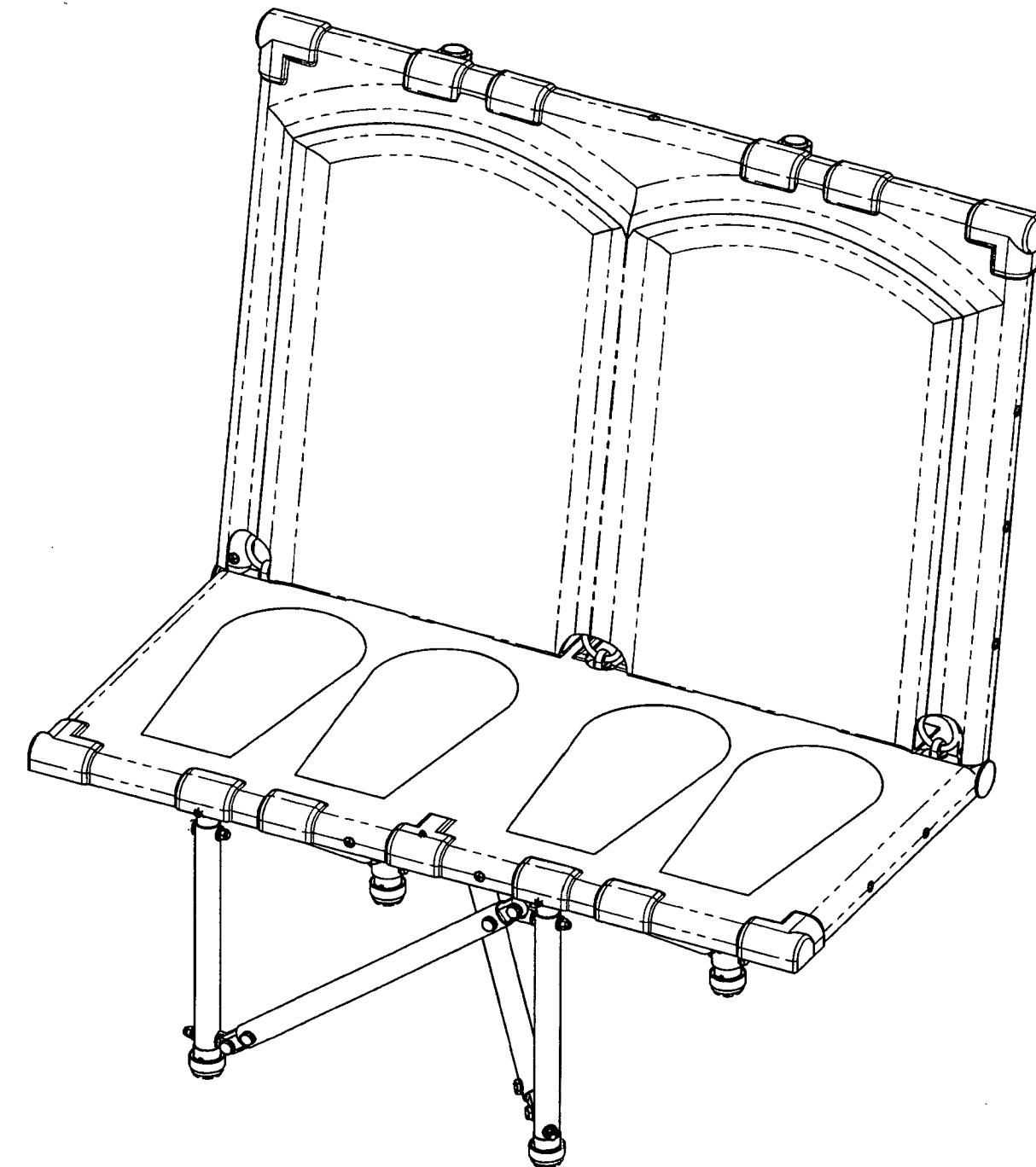
A

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A



D412-769-044 AFT FACING SEAT, RH

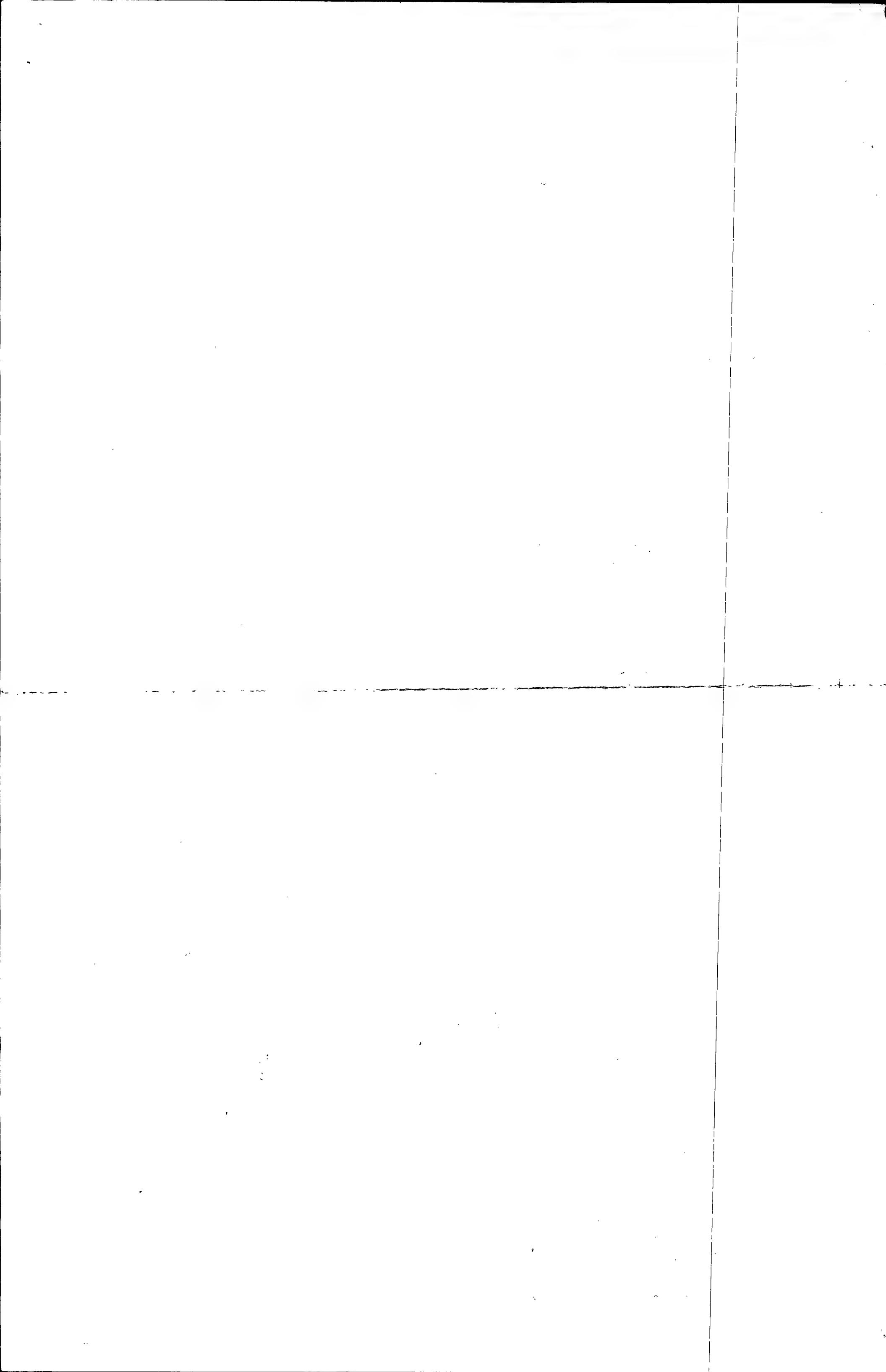
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A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION		
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	PM		
MFG. APPR.	AC		
APPROVED	MM		
DE APPR.	MM	DRAWING NO. D412-769-2	
DATE	08.06.25		

RELEASE
08.07.10
NO. 110821

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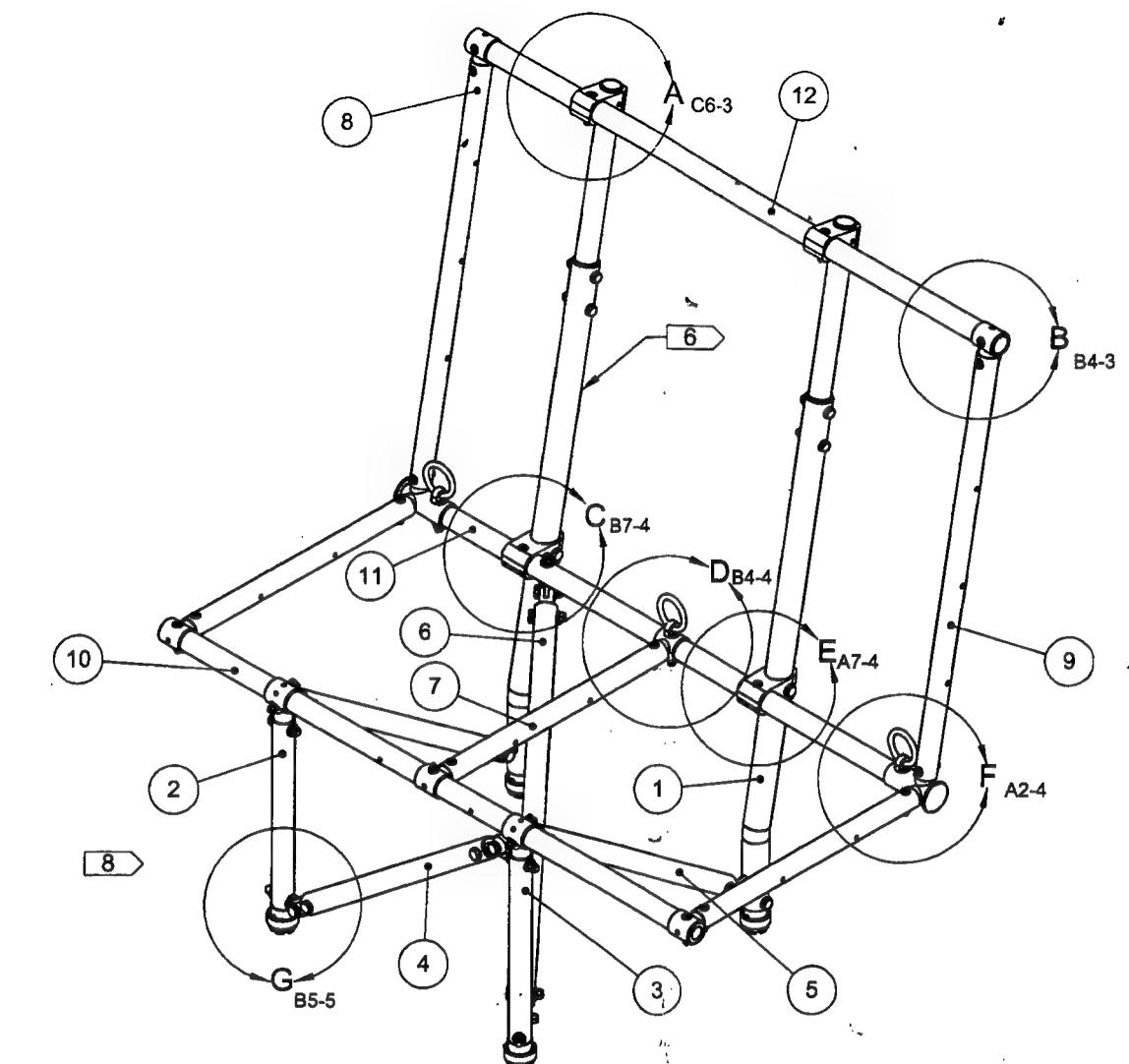
B

B

A

A

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-044	FRONT OUTBOARD LEG ASSY, RH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D3766-2	FRONT RAIL, RH	1
11	D3766-3	REAR RAIL	1
12	D3767-1	UPPER RAIL	1
13	D3792-1	SEAT BELT EYE BOLT	3
14	D3775-1	GUARD	2
15	D3774-1	SEAT BOTTOM	1
16	D3774-3	SEAT BACK	1
17	AN3-5A	BOLT	6
18	AN4-15A	BOLT	2
19	AN45-13A	EYE BOLT	1
20	AN5-10A	BOLT	6
21	AN5-13A	BOLT	2
22	AN525-10R22	SCREW	13
23	AN525-10R24	SCREW	9
24	MS21042L3	NUT	28
25	MS21042L4	NUT	2
26	MS21042L5	NUT	12
27	NAS1149D0332J	WASHER (AN960JD10L)	13
28	NAS1149D0363J	WASHER (AN960JD10)	21
29	NAS1149D0463J	WASHER (AN960JD416)	4
30	NAS1149D0568J	WASHER (AN960JD516)	20



D412-769-044 AFT FACING SEAT, RH

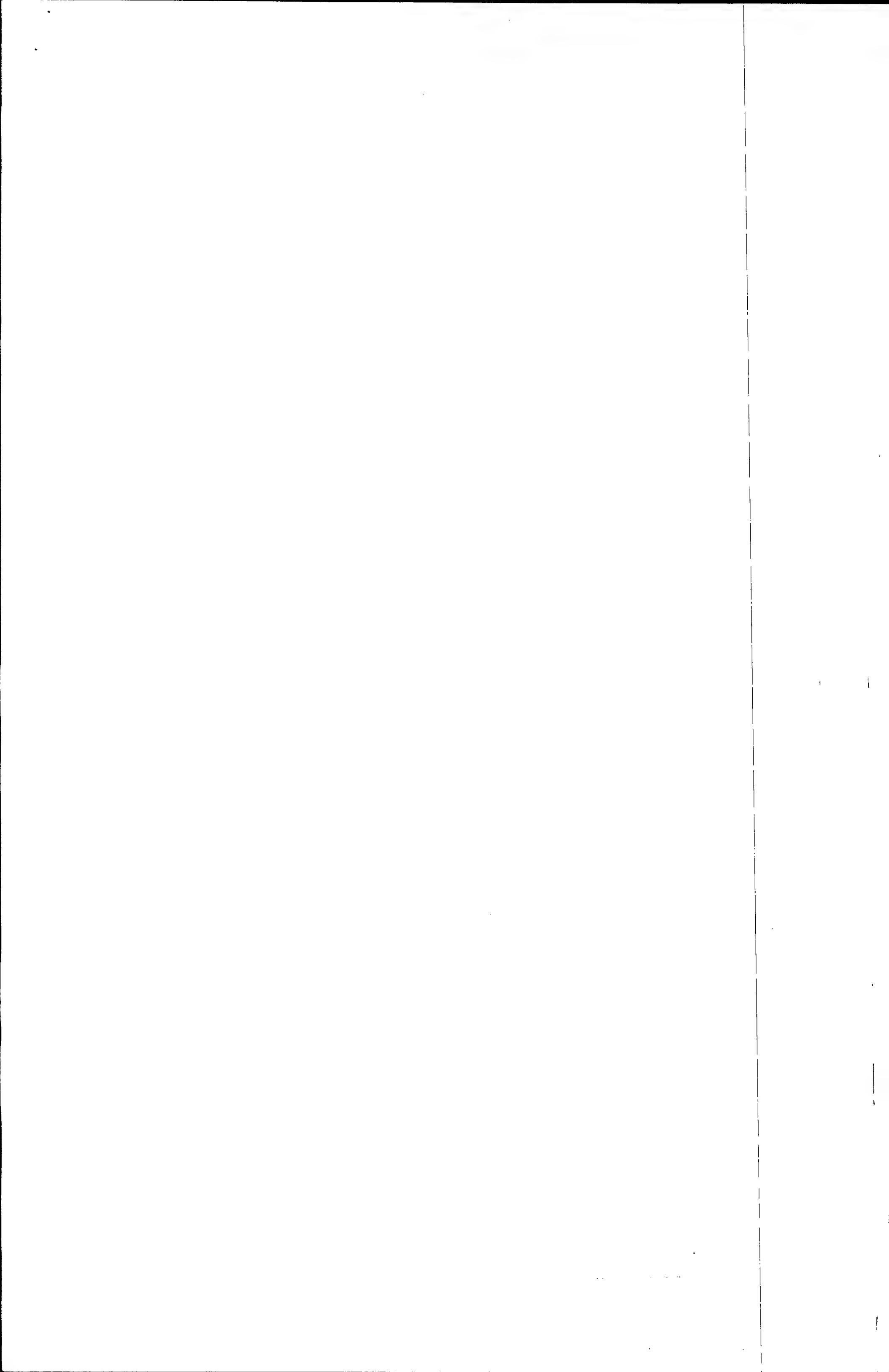
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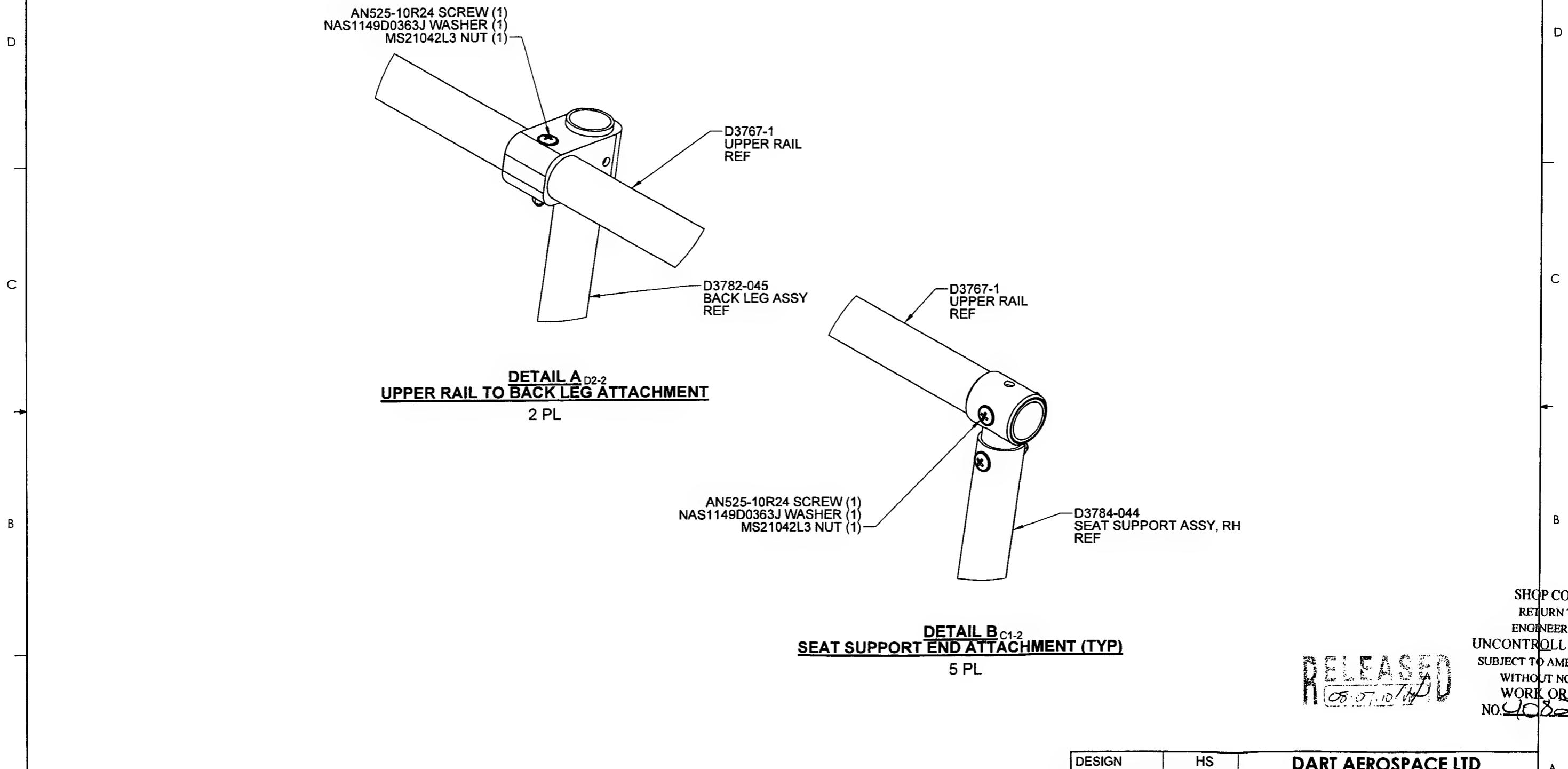
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1, -3). MASK FRONT LEGS PRIOR TO POWDER COAT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO BACK LEG ASSEMBLY (D3782-045)
- 7) WEIGHT: 30.0 lbs
- 8) ITEM 15 (D3774-1 SEAT BOTTOM) AND ITEM 16 (D3774-3 SEAT BACK) REMOVED FOR CLARITY

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	HS	
CHECKED	<i>✓</i>	DRAWING NO.
MFG. APPR.	<i>M</i>	REV. B
APPROVED	<i>M</i>	D412-769-2
DE APPR.	<i>M</i>	SHEET 2 OF 7
DATE	08.06.25	TITLE
		SCALE
		NTS
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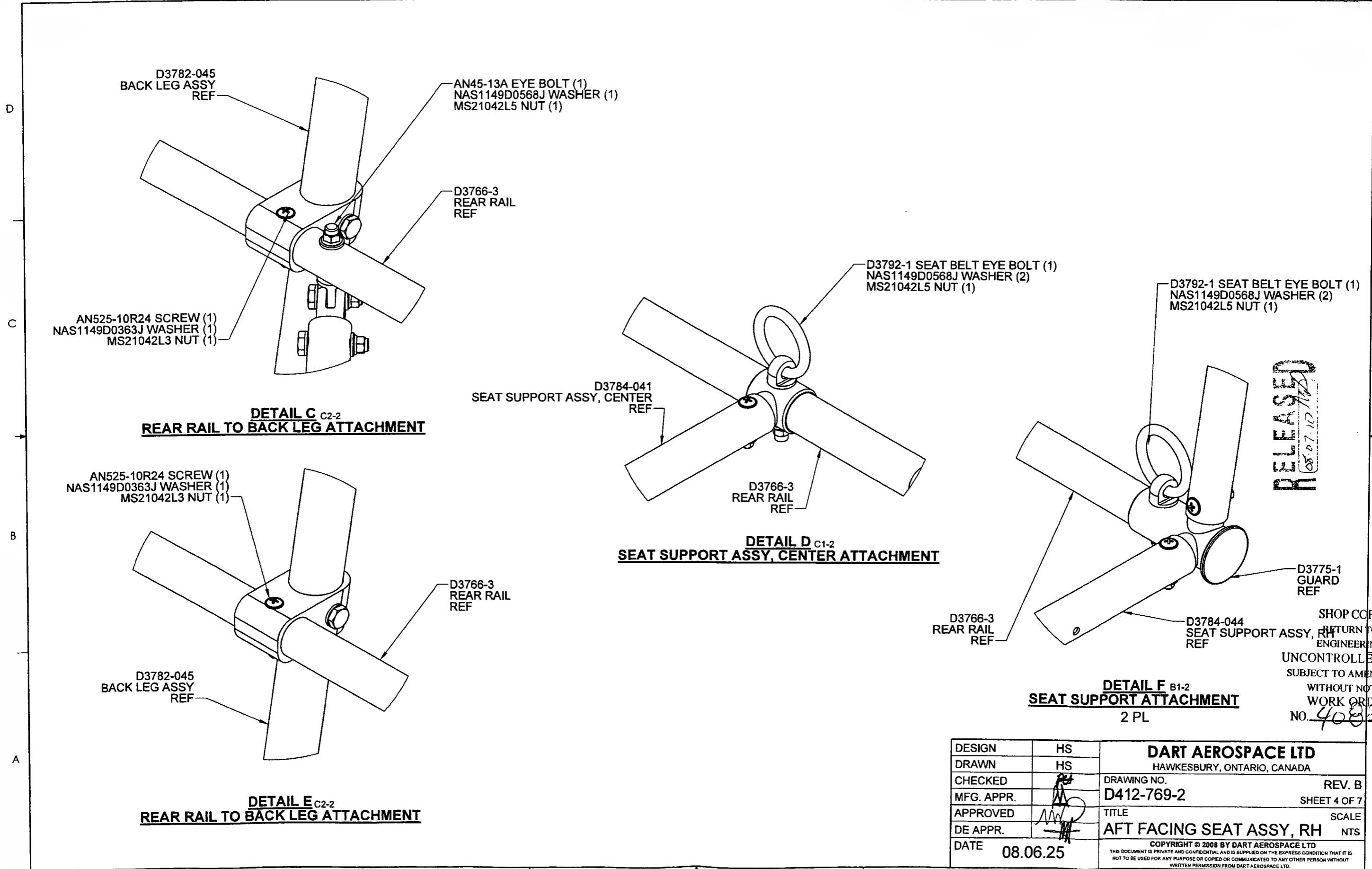


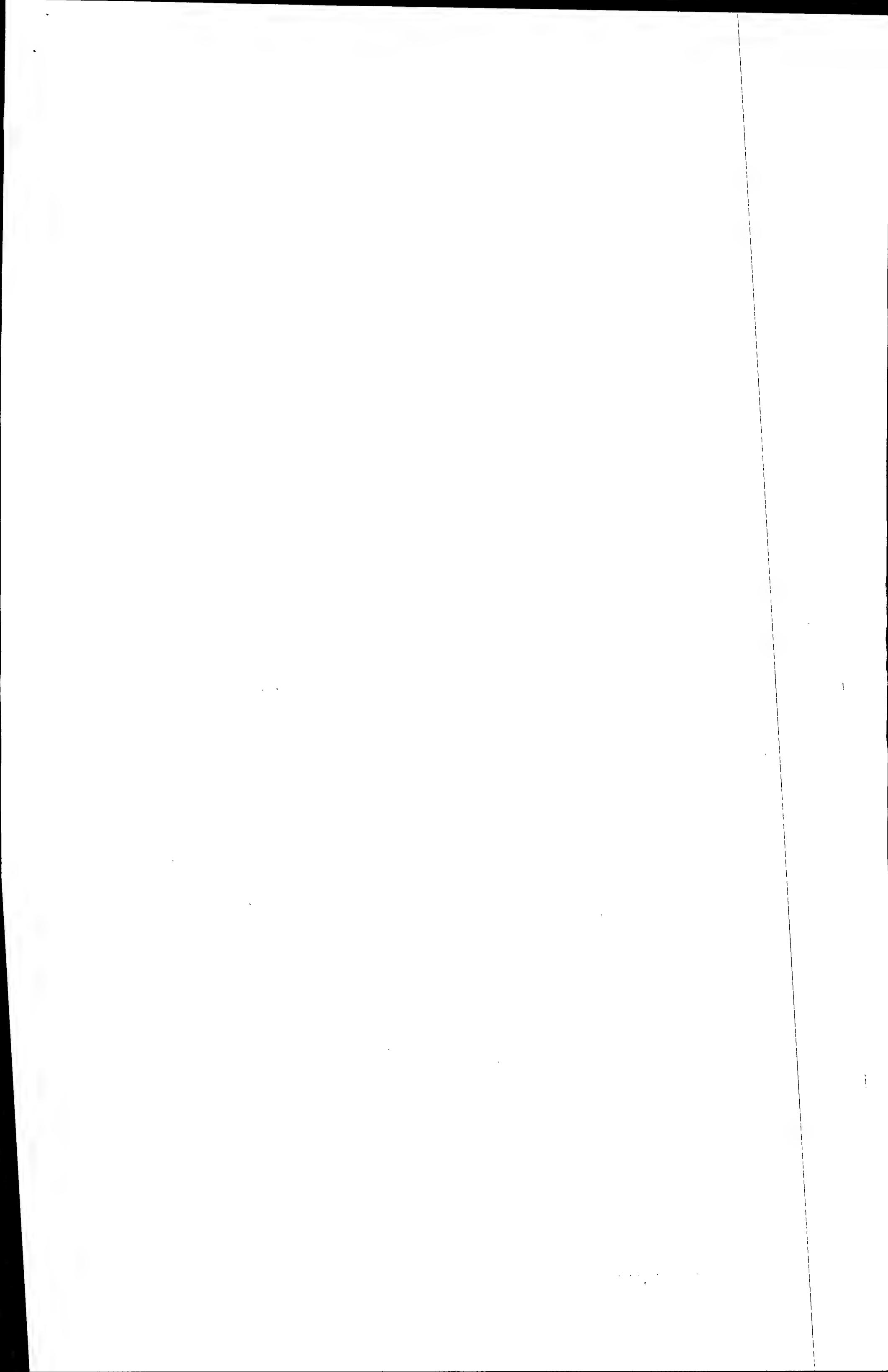
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CHECKED	PS	DRAWING NO.			
MFG. APPR.		D412-769-2	REV. B		
APPROVED	MM		SHEET 3 OF 7		
DE APPR.		TITLE	SCALE		
DATE	08.06.25	AFT FACING SEAT ASSY, RH			
NTS					
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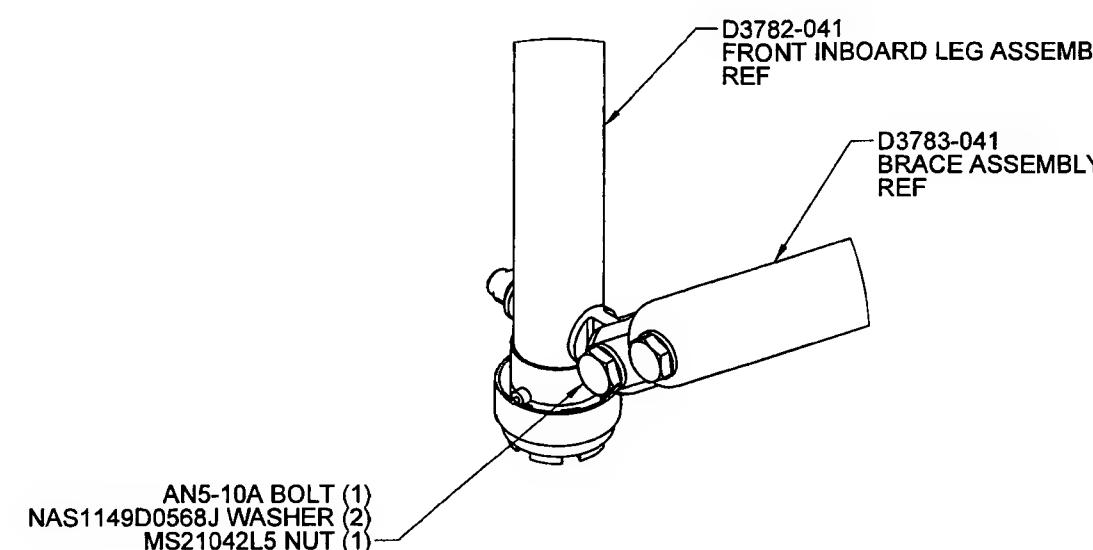
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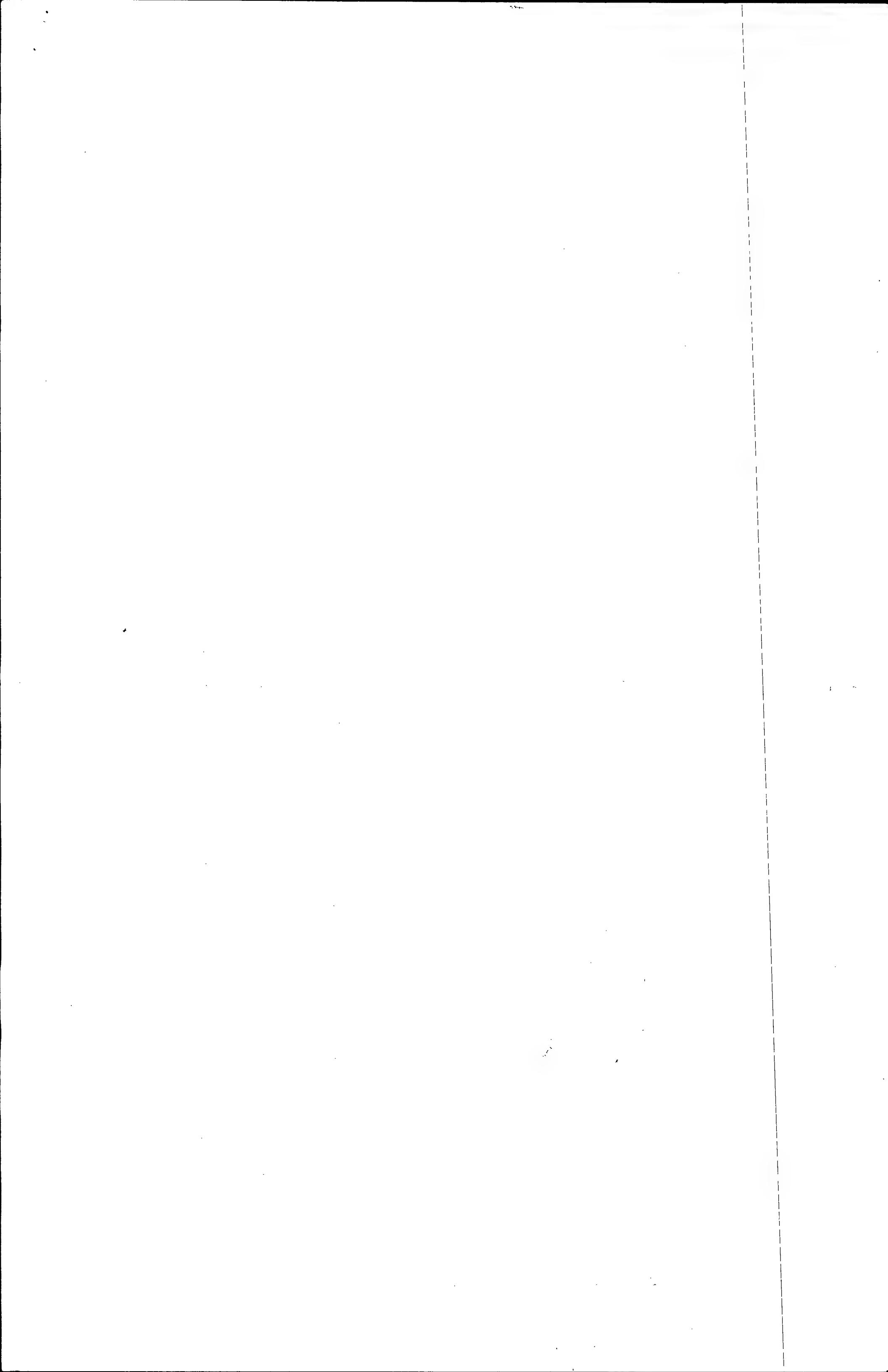


DETAIL G_{B3-2}
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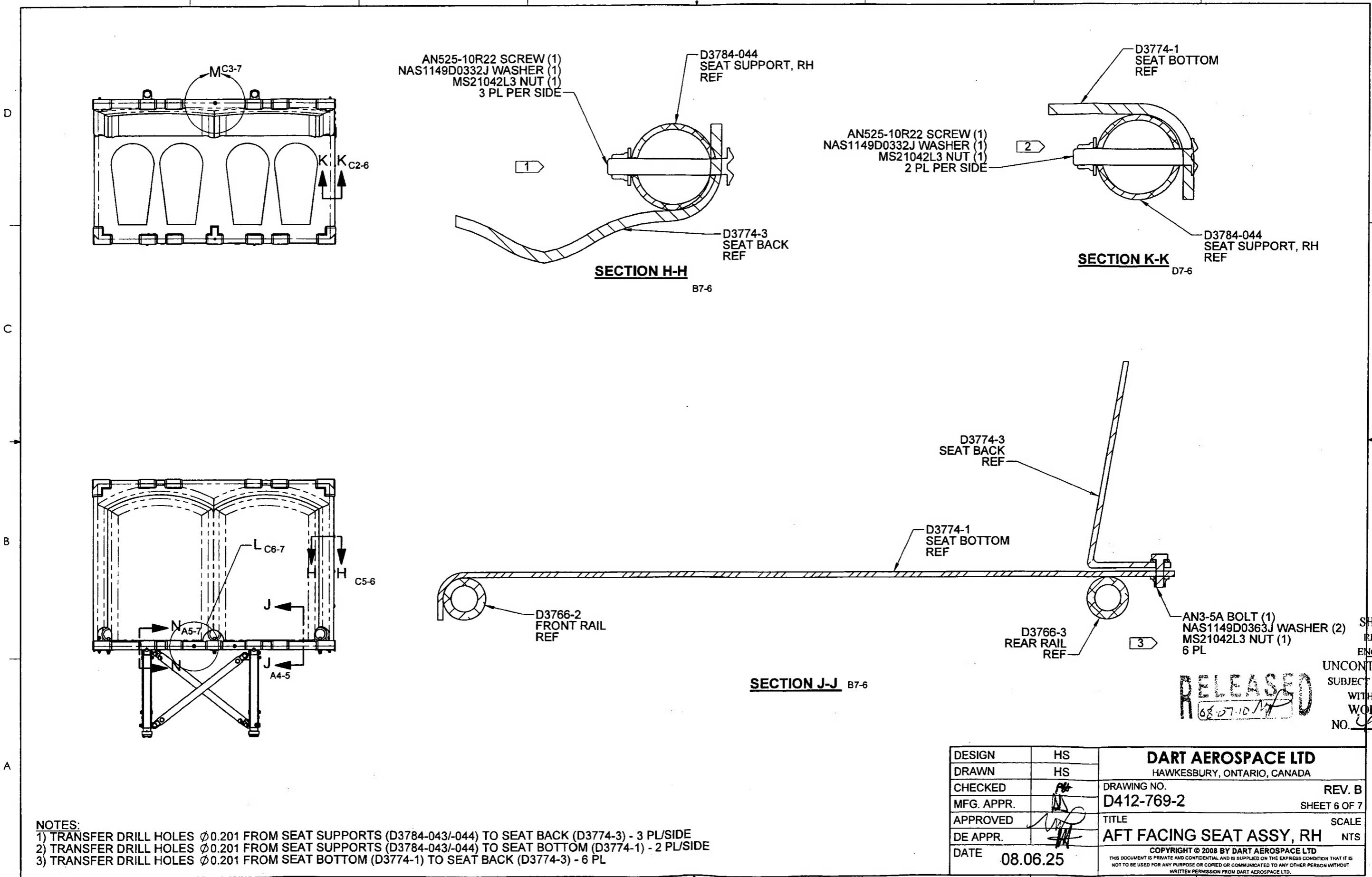
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NO. 40827

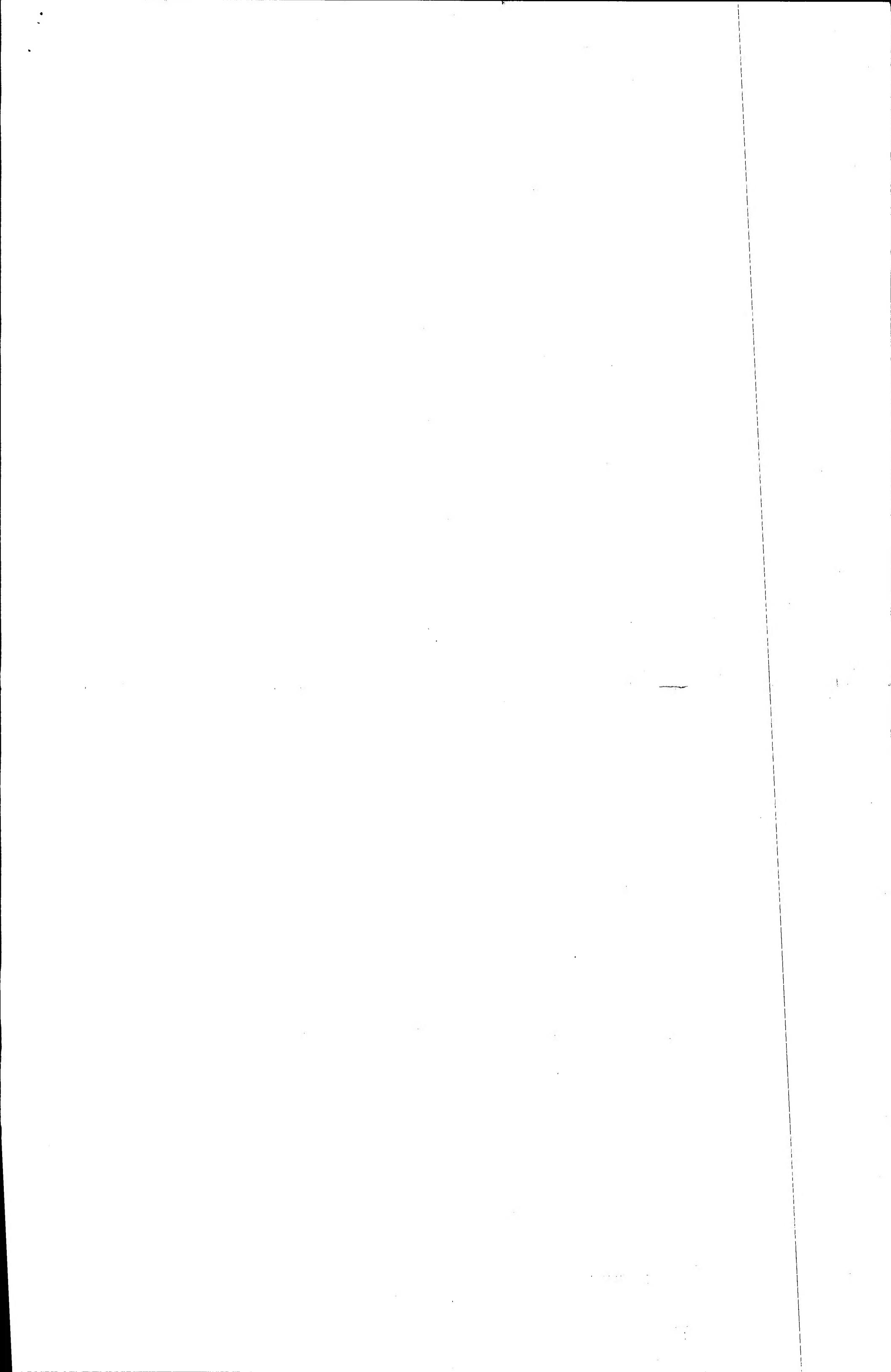
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DRAWN	HS	HAWKESBURY, ONTARIO, CANADA			
CHECKED	PA	DRAWING NO.			
MFG. APPR.	MA	D412-769-2	REV. B		
APPROVED	SM	SHEET 5 OF 7			
DE APPR.	MM	TITLE			
DATE	08.06.25	AFT FACING SEAT ASSY, RH			
SCALE NTS					
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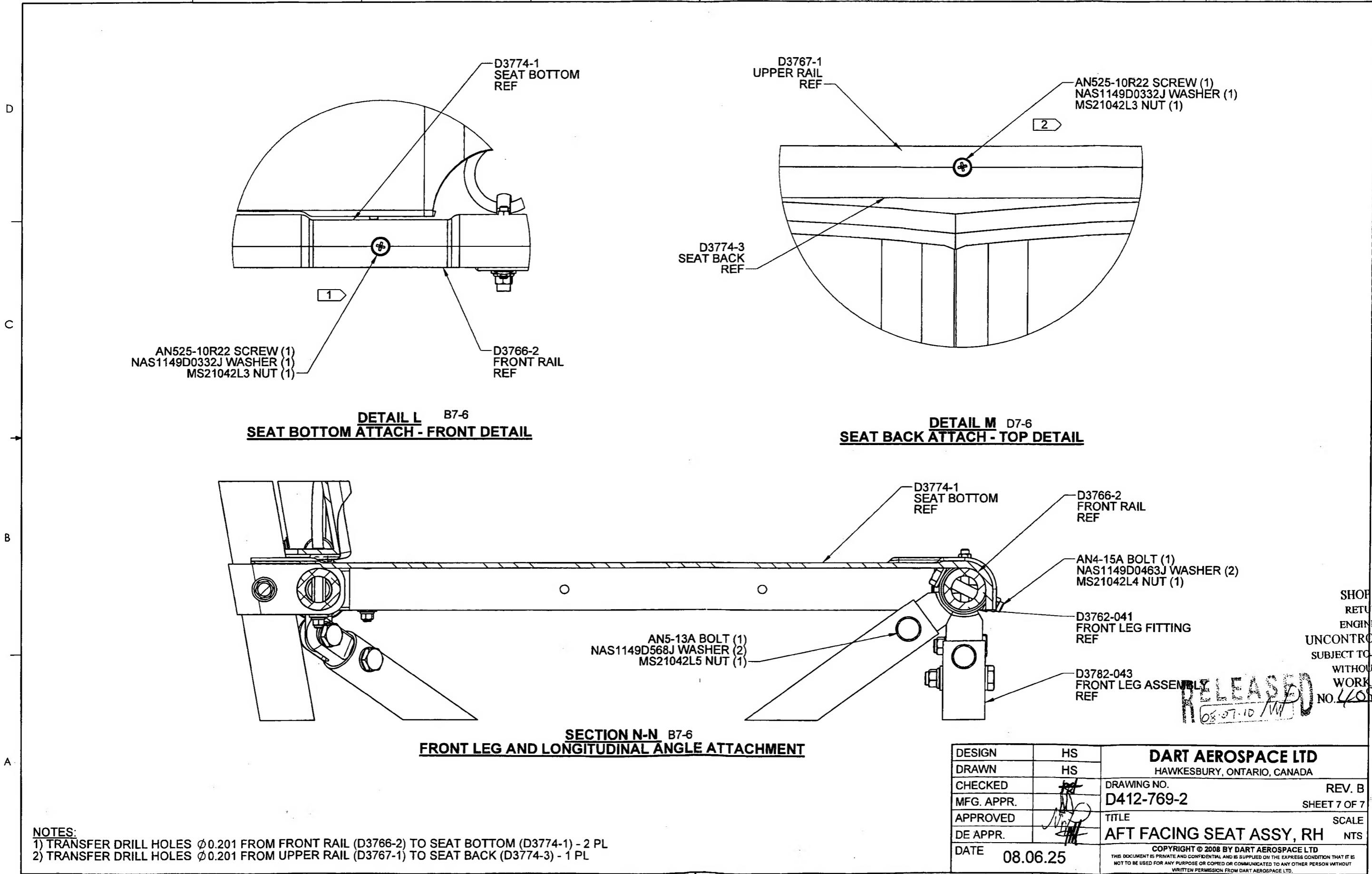
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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

